

Date: Thursday, 21/08/2008 8:27:54 AM
 User: Linda Lacelle

Ship 25/08

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STEP WELDMENT RH (FOLDING)
 Job Number : 41532
 Estimate Number : 11653
 P.O. Number :
 This Issue : 21/08/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D2801042
 Drawing Number : D2801 REV A
 Project Number : N/A
 First Issue : / / Type : LARGE FAB ASSY Drawing Revision : A
 Material :
 Previous Run : 29685 Due Date : 28/08/2008 Qty: 1 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est B01.04.26 Changed D2802-042 to -2 EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2622120C Step Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

X Qty Part # Description Batch:
 1 D2622-120C Extrusion B40937

Check Material for any Dents or Defects

SP 08.08.21 (IX)

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622 extrusion to 86.15" long as per Dwg D2801 SP 08.08.21

2-Deburr and bevel ends for welding

SAP 08/08/21

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/21 (IX)

4.0 D2734 Step End Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch:
 2 D2734 End Cap B36520

B39179

SP 08.08.21

(IX)

Date: Thursday, 21/08/2008 8:27:54 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT RH (FOLDING)

Job Number: 41532

Part Number: D2801042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D28022

Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D2802-2 Arm B35597

SP 08.08.21 (X)

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld arms as per Dwg D2801

SP 08.08.21 (X)

2-Weld one end cap as per Dwg D2801

SP 08.08.21

3-Grind end cap welds flush

SAD 08/08/21 (X)

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-08-21 (X)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/21 (X) (RH)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

KV / SAD 08/08/21 (X)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

S 08/08/21 (X) (RH)

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



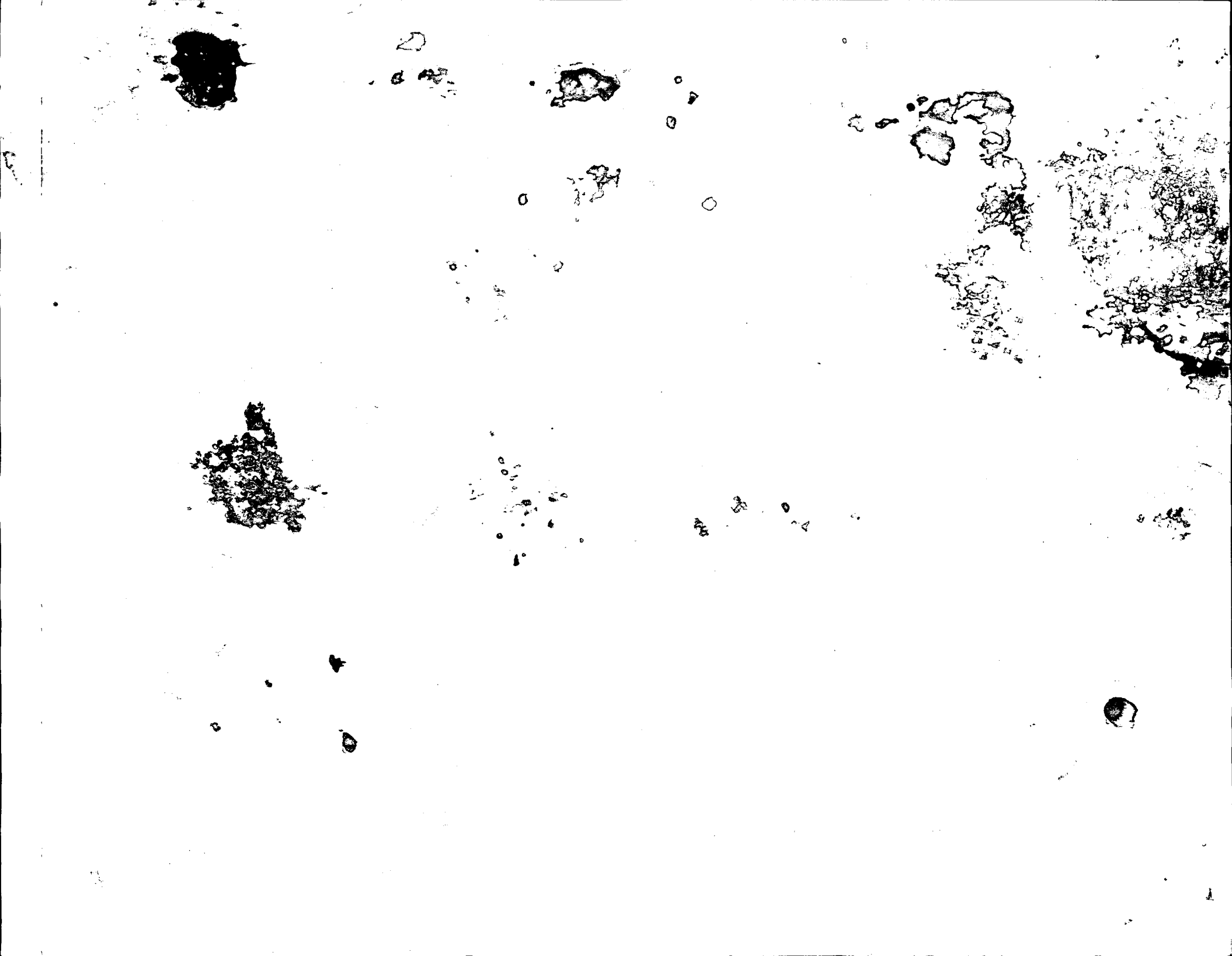
Comment: LARGE FABRICATION RESOURCE 1

1-Weld last end cap as per dwg D2801

SP 08.08.21 (X)

2-Grind welds flush

SAD 08/08/21 (X)



Date: Thursday, 21/08/2008 8:27:55 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT RH (FOLDING)

Job Number: 41532

Part Number: D2801042

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PS 08/08/21

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/21 (RH)

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch-up alodine

217/FL 08/08/21 (X1)

15.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

8:00

OVEN TEMPERATURE:

320°

FINISH TIME:

8:30

FL 08/08/22

(1)

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-08-22

(2)

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D2801 and QSI 005 4.4

FL 08/08/22

(1)

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/25 (A)

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Draft

8/8/25

810

Date: Thursday, 21/08/2008 8:27:55 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT RH (FOLDING)

Job Number: 41532

Part Number: D2801042

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

QC21

FINAL INSPECTION/W/O RELEASE



08/08/25

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

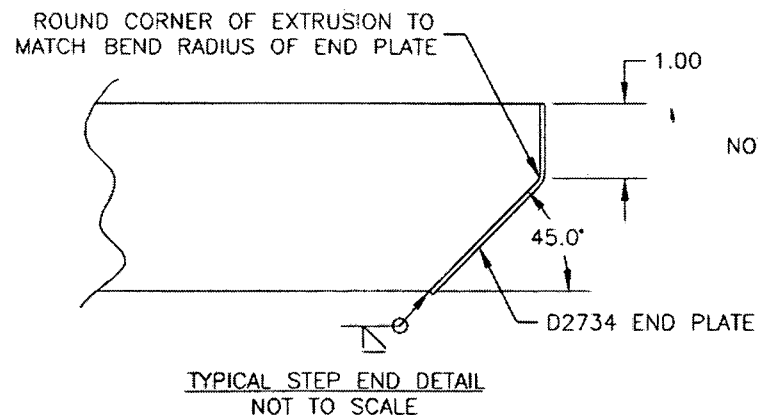


U 08/08/25

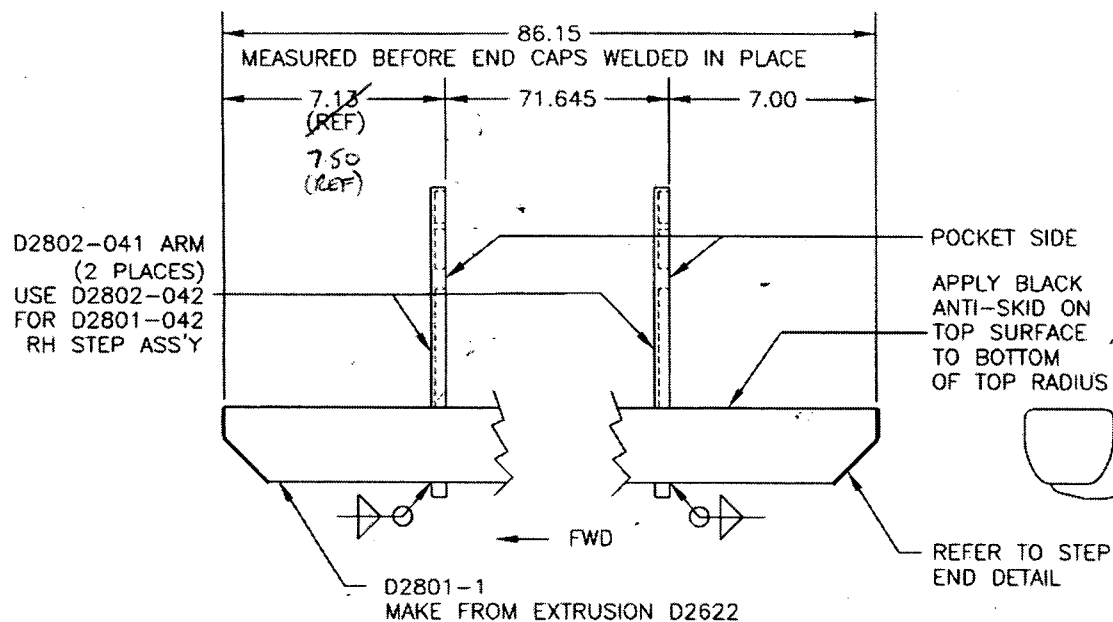
DART

CA COPY ISSUED

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004



W/O 28576



D2801-041 LH STEP ASSEMBLY (SHOWN)
D2801-042 RH STEP ASSEMBLY (OPPOSITE)

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
WELD PER DART QSI 004 UNLESS OTHERWISE NOTED
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ENTIRE ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED <i>CP</i>	APPROVED <i>CP</i>	HAWKESBURY, ONTARIO, CANADA
DATE 00.11.03	TITLE STEP WELDMENT	REV. A
A	00.11.03	NEW ISSUE
A1	03.08.15	7.50 WTS 7.13
SHEET 1 OF 1		
SCALE NTS		

RELEASED
00.11.13